

**Work Order ID 71668**

Thursday, July 07, 2011 12:09:43 PM



Page 1

Item ID: D3535-37

Accept



Setup Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 7/7/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 7/21/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: CLDate: 11/07/07

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3535	Rev B

100



FLOW WATER JET

0.00

11/07/1510

Waterjet

Memo

0.00

FLOW CNC Waterjet

I-Cut as per Dwg D3535    Dwg Rev: B    Prog Rev: B    2-  
Deburr if necessary

110



QC2- Inspect parts off machine FAI/FAIB

0.00

11/07/1510

QC

Memo

0.00

Quality Control

120



QC8- Inspect parts - second check

0.00

SmarterECO

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Start Qty: 10.00



Cust Item ID:

Required Date: 7/21/2011

Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

130

Operation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Brake NC

NC BRAKE

0.00

Brake NC

Memo

0.00

1-Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326.  2- Identify as D3535-37

140



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

150



Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Memo

0.00

Powdercoat

START TIME: 8:40OVEN TEMPERATURE: 910

Powder Coating

FINISH TIME: 3:00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 71668**

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Setup Start



Revision ID:

Item Name: Wearshoe

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Start Date: 7/7/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 7/21/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160



QC3- Inspect Part Finish

0.00

10 0 10 10-125

QC

Memo

0.00

Quality Control

170



Identify as per dwg &amp; Stock Location:

FD-18

0.00

10 0 10 11-7-25

Packaging

Memo

0.00

Packaging

180



QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10 0 10 11-7-25

10 11-07-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

Page 1

Thursday, July 07, 2011 12:09:40 PM

Work Order ID: 71668



Parent Item: D3535-37



Parent Item Name: Wearshoe

Start Date: 7/7/2011

Required Date: 7/21/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A New Issue 07-02-15 JLM  
IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA 		Purchased		No		100	sf	134.1630	0.7955	8.373684 			

304/316 .040 Sheet

Location	Loc Qty	Loc Code
MAT020	134.163	
116623	0.2	
117550	9.363	
117933	124.6	

8/5/15 11/01/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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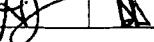
DART AEROSPACE LTD		Work Order:	71668
Description: Wearshoe		Part Number:	D3535-37
Inspection Dwg: D3535 Rev: B		Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

First Article  Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.188	+0.005/-0.001	0.190	—		RAZ6	Vern
0.300	+/-0.010	.302	—		"	
0.300	+/-0.010	.302	—		"	
1.885	+/-0.010	1.886	—		"	
2.000	+/-0.010	2.000	—		RA04	TAPE
4.750	+/-0.010	4.75	—		"	
9.500	+/-0.010	9.50	—		"	
14.250	+/-0.010	14.25	—		"	
17.750	+/-0.010	17.75	—		"	
22.500	+/-0.010	22.50	—		"	
27.250	+/-0.010	27.25	—		"	
30.750	+/-0.010	30.75	—		"	
6.00	+/-0.030	6.00	—		"	
8.00	+/-0.030	8.00	—		"	
16.00	+/-0.030	16.00	—		"	
21.00	+/-0.030	21.00	—		"	
0.040	+/-0.010	.034	—		RAZ6	Vern

Measured by:		Audited by:		Prototype Approval:	N/A
Date:	11/07/15	Date:	WCA/15	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.10.16	New Issue	KJ	

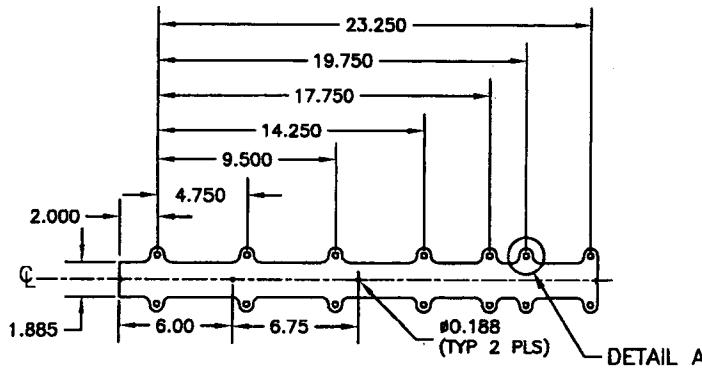
**DART**

DESIGN <b>CB</b>	DRAWN BY <b>PH</b>	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED <b>✓</b>	APPROVED <b>✓</b>	DRAWING NO. <b>D3535</b>
DATE <b>07.04.17</b>	TITLE <b>WEARSHOE</b>	REV. B SHEET 5 OF 7 SCALE <b>1:10</b>

RELEASED  
07.04.14

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 71668

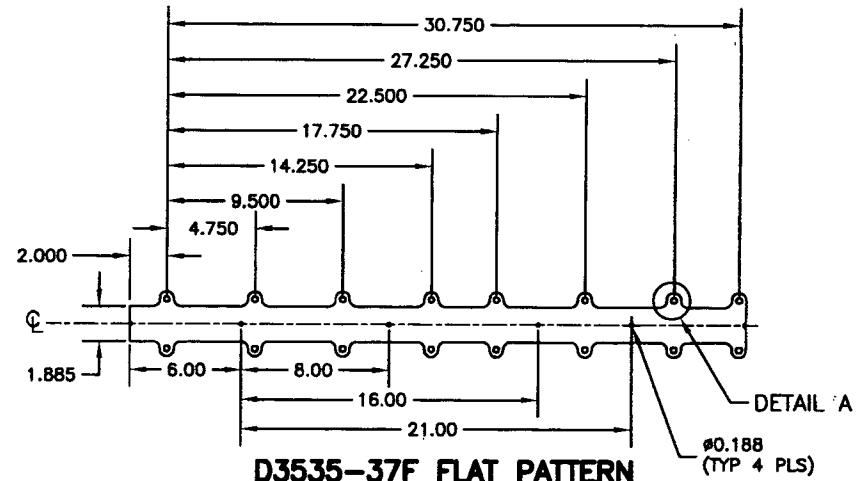
CD 11107/07



**D3535-35F FLAT PATTERN**



**D3535-35 BEND DETAIL**



**D3535-37F FLAT PATTERN**



**D3535-37 BEND DETAIL**

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